

**PROCESS FOR PREPARING ETHER-CAPPED POLY(OXYALKYLATED)
ALCOHOL SURFACTANTS
ABSTRACT OF THE INVENTION**

A process for preparing an ether-capped poly(oxyalkylated) alcohol surfactant is provided. The alcohol has the formula:



wherein, R is selected from the group consisting of linear or branched, saturated or unsaturated, substituted or unsubstituted, aliphatic or aromatic hydrocarbon radicals having from about 1 to about 30 carbon atoms; R¹ may be the same or different, and is independently selected from the group consisting of branched or linear C₂ to C₃ alkylene in any given molecule; x is a number from 1 to about 30; and R² is selected from the group consisting of:

- (i) a 4 to 8 membered substituted, or unsubstituted heterocyclic ring containing from 1 to 3 hetero atoms; and
- (ii) linear or branched, saturated or unsaturated, substituted or unsubstituted, cyclic or acyclic, aliphatic or aromatic hydrocarbon radicals having from about 1 to about 30 carbon atoms;

provided that when R² is (ii) then either at least one of R¹ is other than C₂ to C₃ alkylene or R² has from 6 to 30 carbon atoms.